

Date: Thursday, 07/08/2008 4:23:20 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 41067		
Estimate Number	: 12578		
P.O. Number	:	Part Number	: D3560041
This Issue	: 07/08/2008 S.O. No. :	Drawing Number	: D3560 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: D
Previous Run	: 40299	Material	:
Written By	:	Due Date	: 26/08/2008
Checked & Approved By	: <u>NO 08 8.08</u>	Qty:	40 Um: Each
Comment	: Est Rev:A New Issue 07.05.24 EC		
	est rev B ECN 987 07.10.09 EC verified by: DD		
	Est Rev:C ECN1048 07-12-18 DD verified by: EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.4648 f(s)/Unit Total : 14.6475 f(s)  
 6061-T6 Bar 0.50" x 5.00"  
 Batch: M108254

28 08/08/23 (12)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW  
 Cut blanks 16.750" long

28 08/08/23 (12)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

- 1- Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D
- 2-C'sink 0.196" hole on manual mill as per dwg D3560
- 3-Deburr per dwg D3560

JL 08/08/25

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/08/25



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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41067

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SP 08/08/25 (12)

6.0

D35921

Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

PLATE

Batch: B35331

SP 08.08.29 (1X)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3560

STEP:

- 1- clean material (buff bracket and bottom of arm with blue pad ) SP
- 2- set up bracket and arm on jig SP
- 3- preheat bracket and arm with torch SP
- 4- clean before welding with brush SP
- 5- set up machine to 135 amps SP
- 6- weld across bottom and top ends SP
- 7- reheat with torch ( 65 deg C ) SP
- 8- on one side weld from bottom to top half way SP
- 9- same for other side (half way) SP
- 10- from half way point weld the rest of the first side (ease off pedal near end) SP
- 11- same for remaining side (ease off pedal near end) SP

SP 08.08.29 (1X)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/08/29 (1X)

SP 08.08.29 (1X)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SP 08.08.29 (1X)





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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 41067

Part Number: D3560041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

*Handwritten initials*

08/08/29

(27)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-09-02

X1

12.0

D2808

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Spacer

batch:

*B37113*

*Handwritten signature*

13.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press bushing in D3560 arm per dwg D3562

*Handwritten signature*

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten signature*

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*152*

*8/9/12*

*51*

16.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/15

Job Completion



*mk 08-09-15*











**RELEASED**  
07.12.12

D3592-1 PLATE

D3560-1 ARM

D3560-2 ARM

D3592-1 PLATE

A

B

**D3560-04 RM WELDMENT**

D3592-1 PLATE

D3560-3 AR-D3560-4 ARM

D3592-1 PLATE

**D3560-043 A ARM WELDMENT**

8

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41067

DETAIL A  
SCALE 1:2

DETAIL B  
SCALE 1:2

FIT NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
COAT	CP	07.06.19
MENT, ADD POCKETS	CP	07.01.15
	CP	06.09.25
DESCRIPTION	BY	DATE

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE SPECIFIED
- 4) UNITS: INCHES UNLESS OTHERWISE SPECIFIED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 IN
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.23 lbs (TYP)
- 8) WELDING: PER DART QSI 004

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

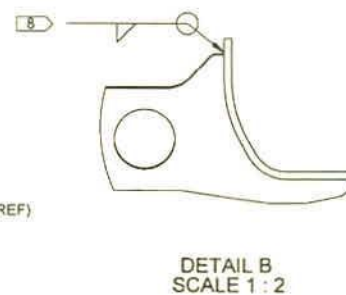
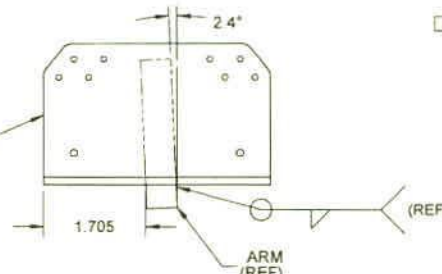
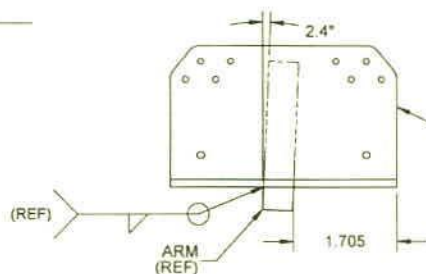
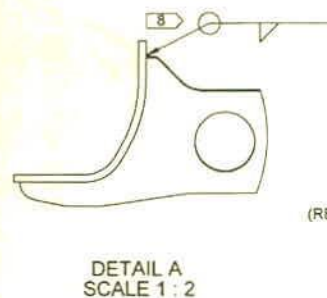
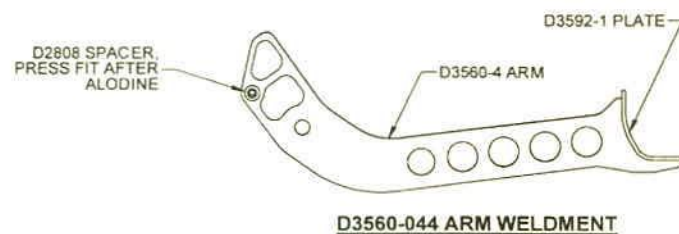
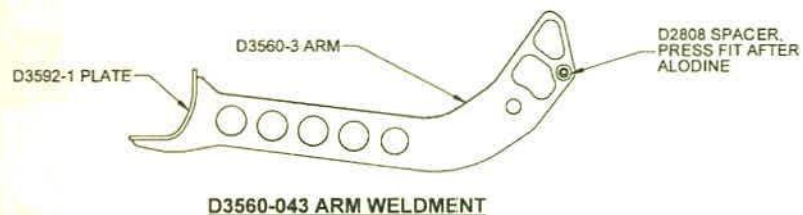
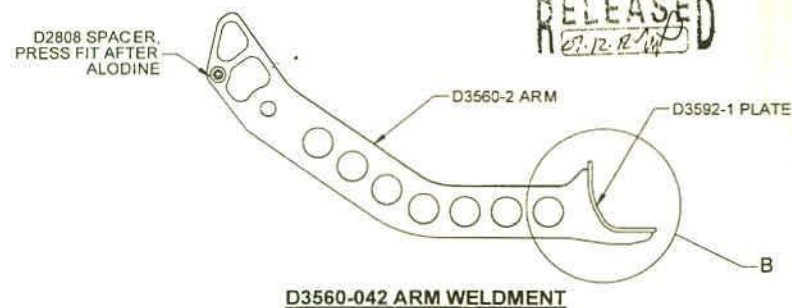
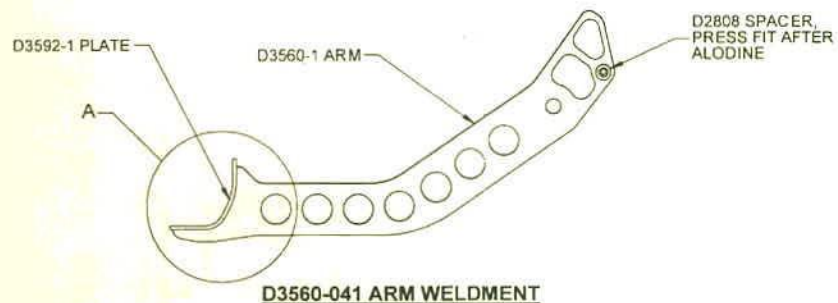
DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5

TITLE **ARM WELDMENT** SCALE 1:4

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RELEASED  
02.12.14



**PARTS LIST**

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

D	ADD D2808 PRESS FIT NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	REMOVE POWDER COAT	CP	07.06.19
B	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
A	NEW ISSUE	CP	06.09.25
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG APPR.			
APPROVED			
DE APPR.			
DATE	07.11.16		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3560** REV. D  
SHEET 1 OF 5  
TITLE **ARM WELDMENT** SCALE 1:4

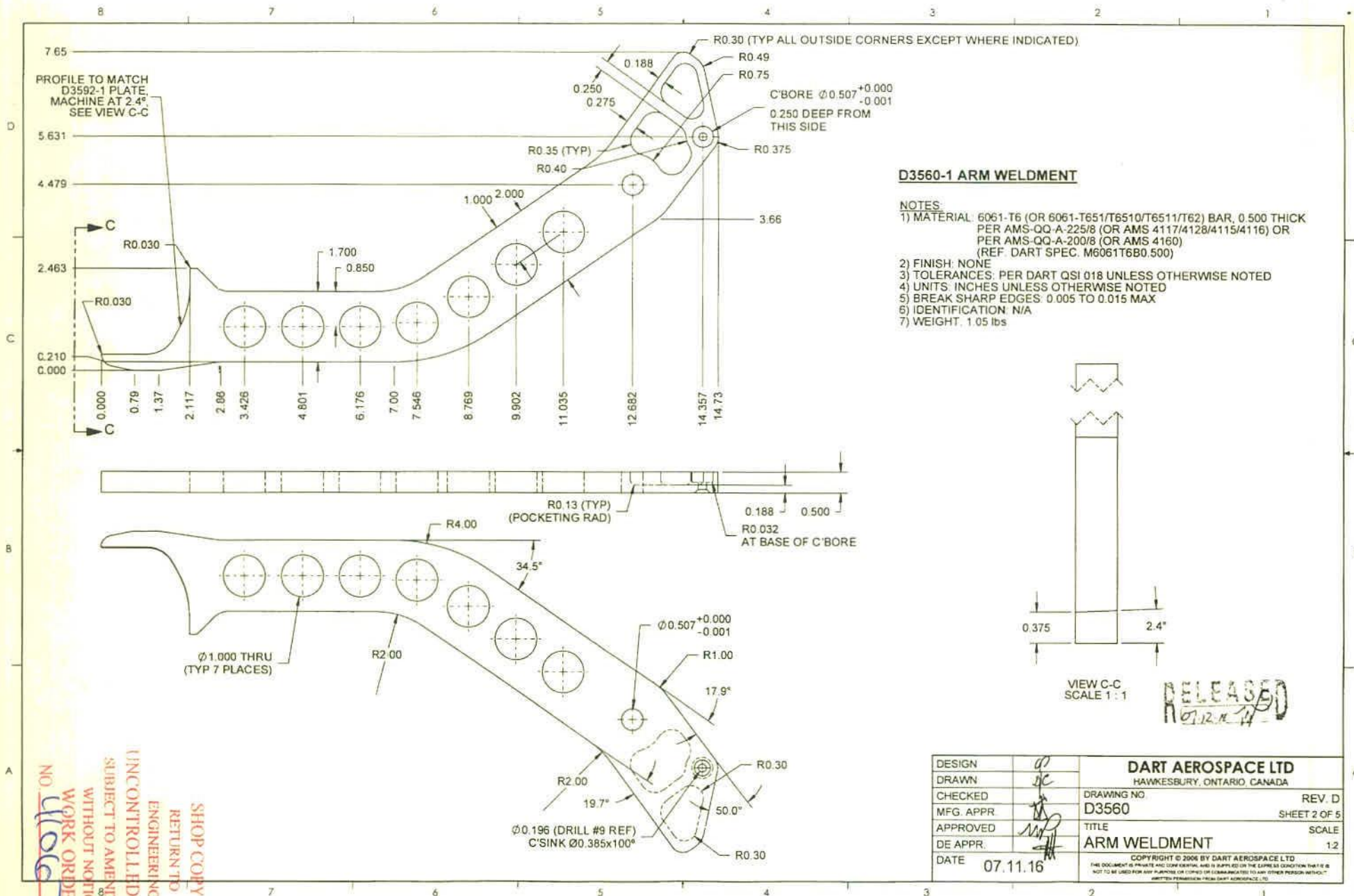
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NOTES:  
1) MATERIAL: N/A  
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: 1.23 lbs (TYP)  
8) WELDING: PER DART QSI 004

NO WORK ORDER  
TO AMENDMENT  
ENGINEERING  
RETURN TO  
DROP COPY







# **D3560-1 ARM WELDMENT**

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK  
 PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
 PER AMS-QQ-A-200/8 (OR AMS 4160)  
 (REF. DART SPEC. M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs

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The following is a list of the names of the persons who have been  
 elected to the office of the Board of Directors of the  
 City of New York, for the year 1898.

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